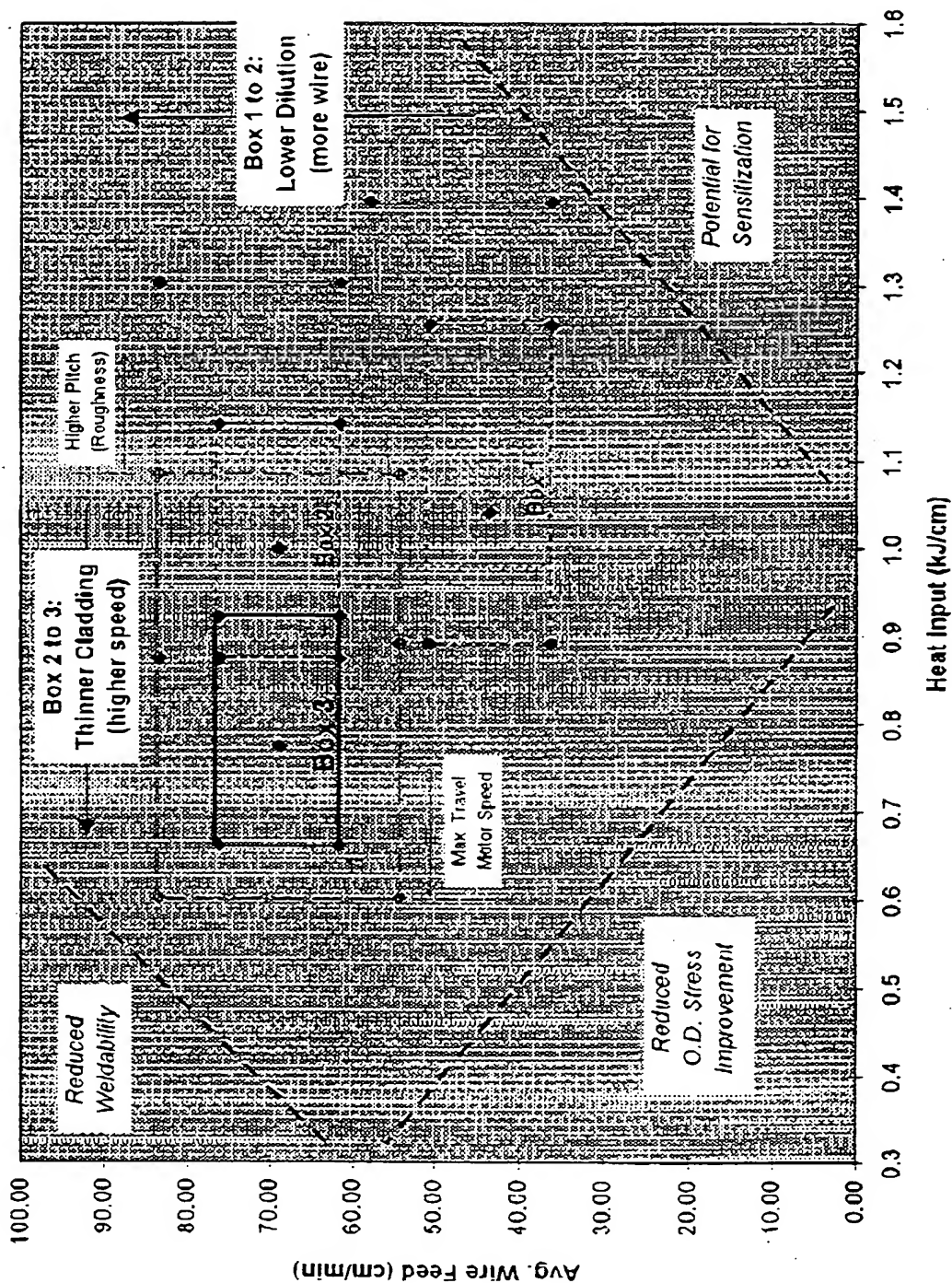


FIG. 1

Heat Boxes 1, 2, 3 (with Reference Points)



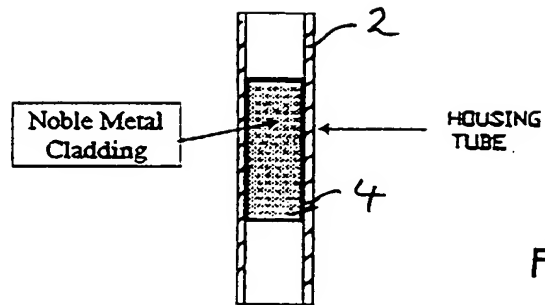


FIG. 2A

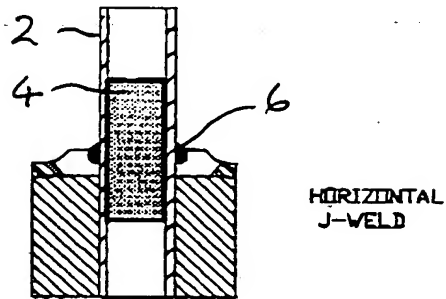


FIG 2B

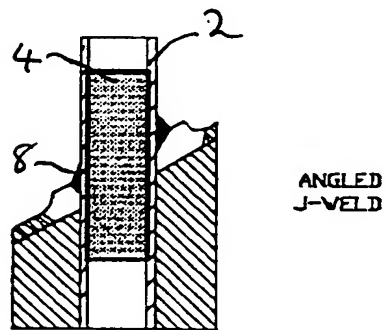


FIG 2C

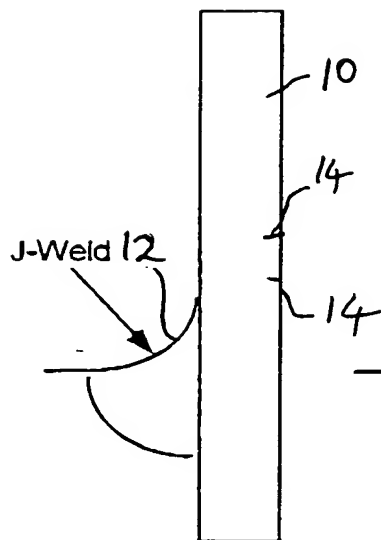


FIG. 3A
Shallow
Cracks

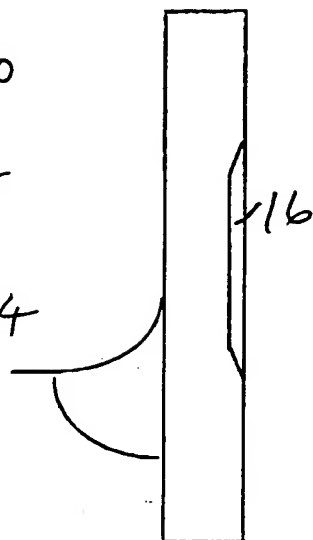


FIG. 3B
Cracks
Removed

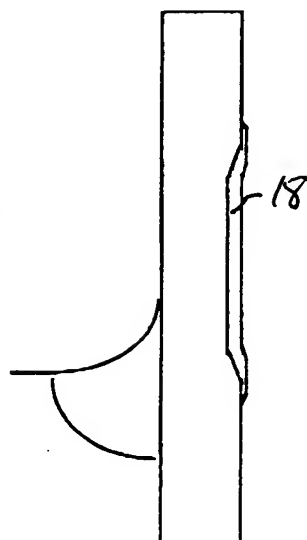


FIG. 3C
Counterbore
NM Cladded

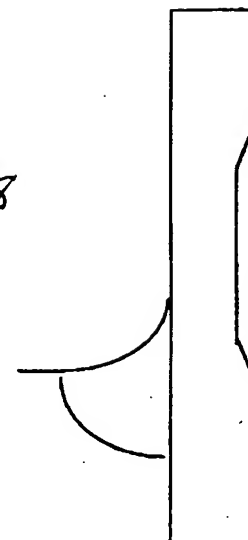
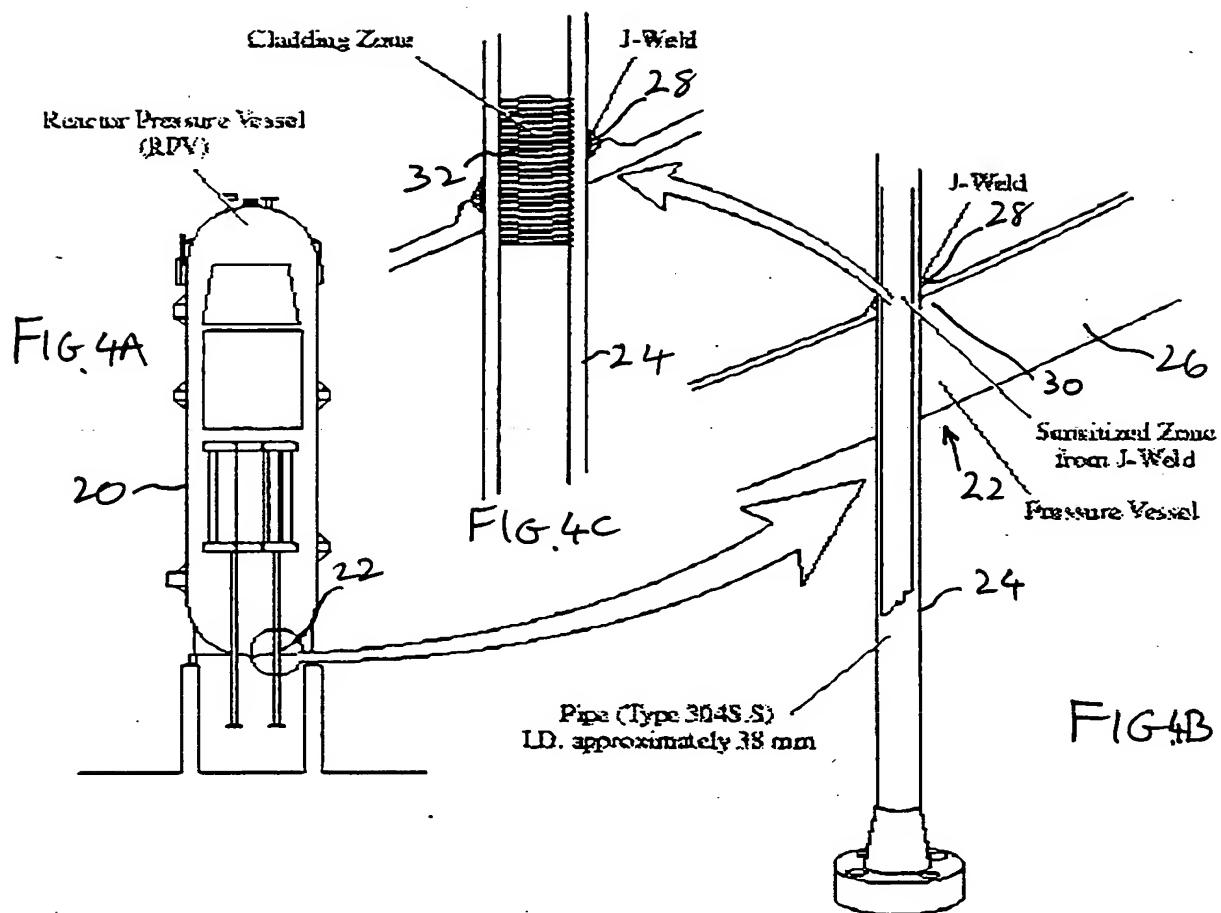


FIG. 3D
ID Surface
Finished



ICMH Mitigation

FIG. 4

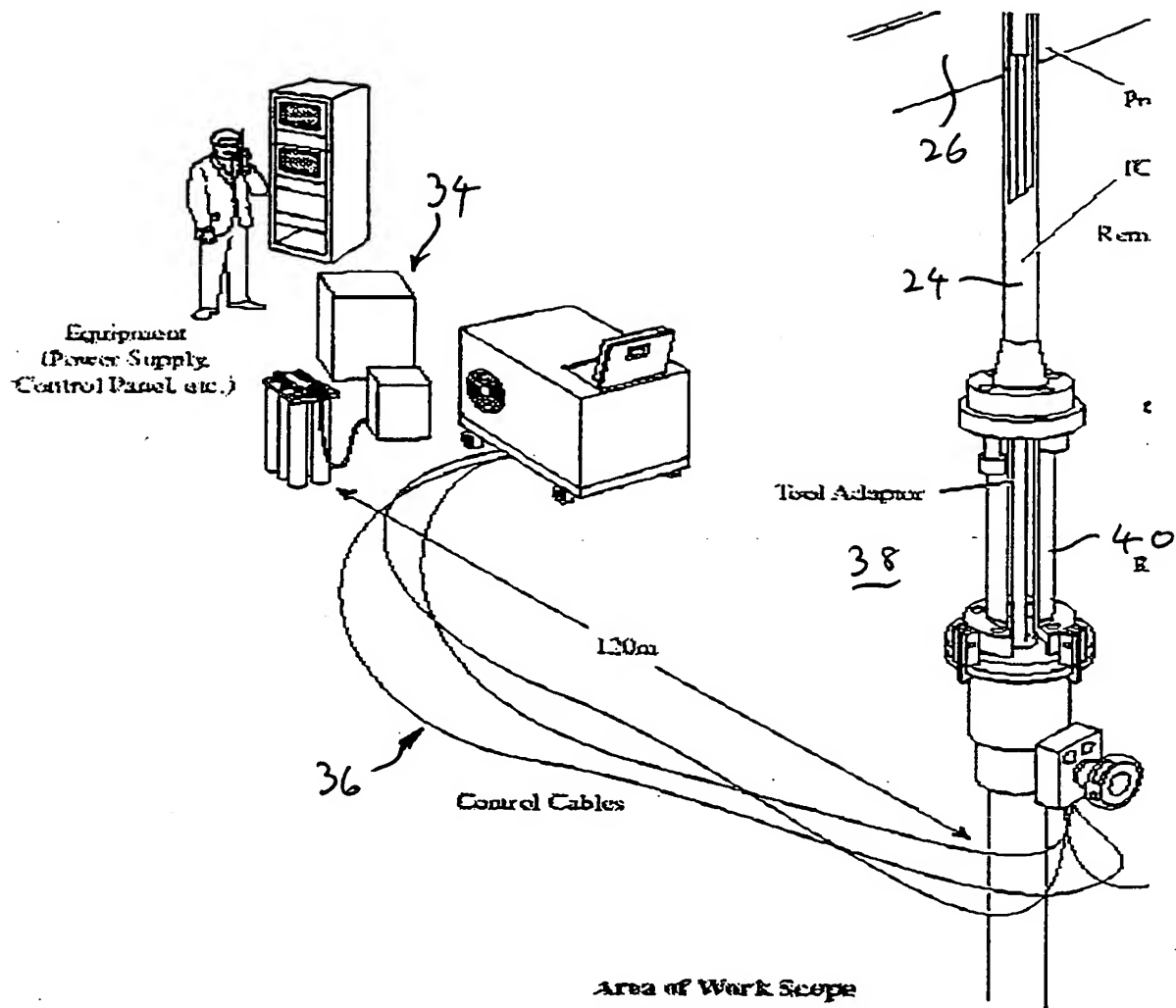


FIG. 5

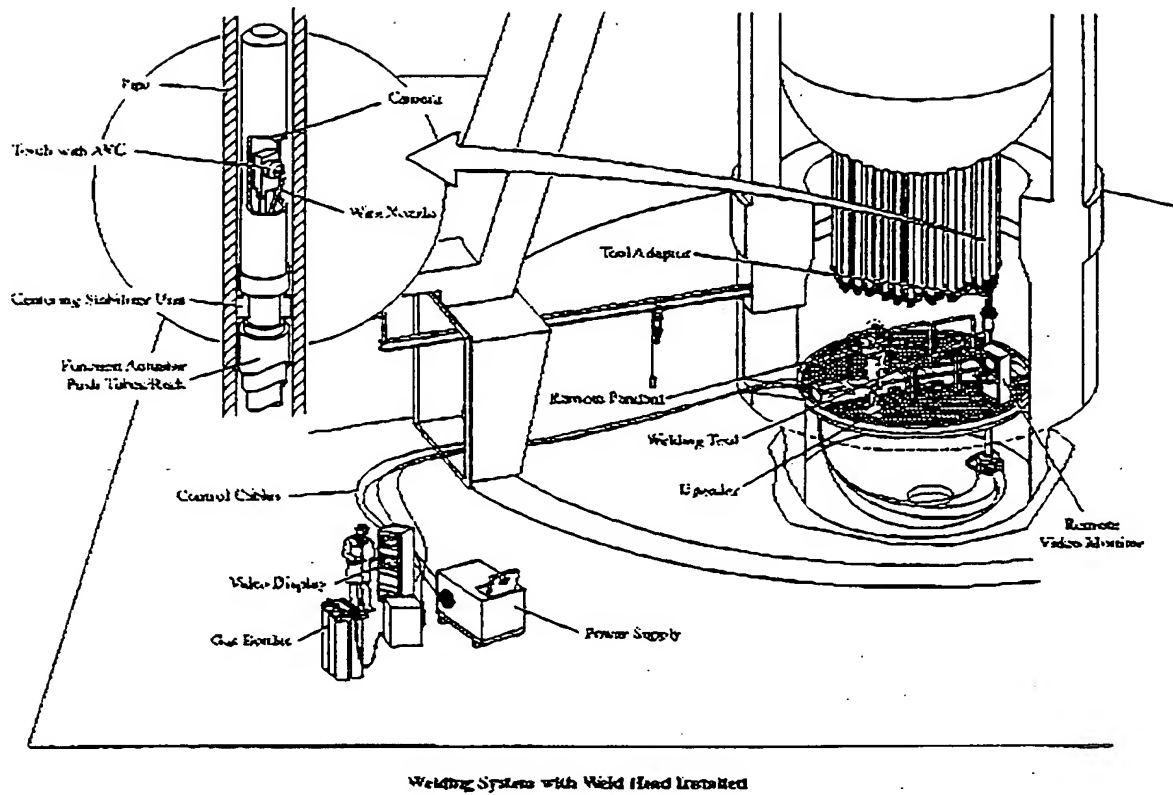


FIG. 6

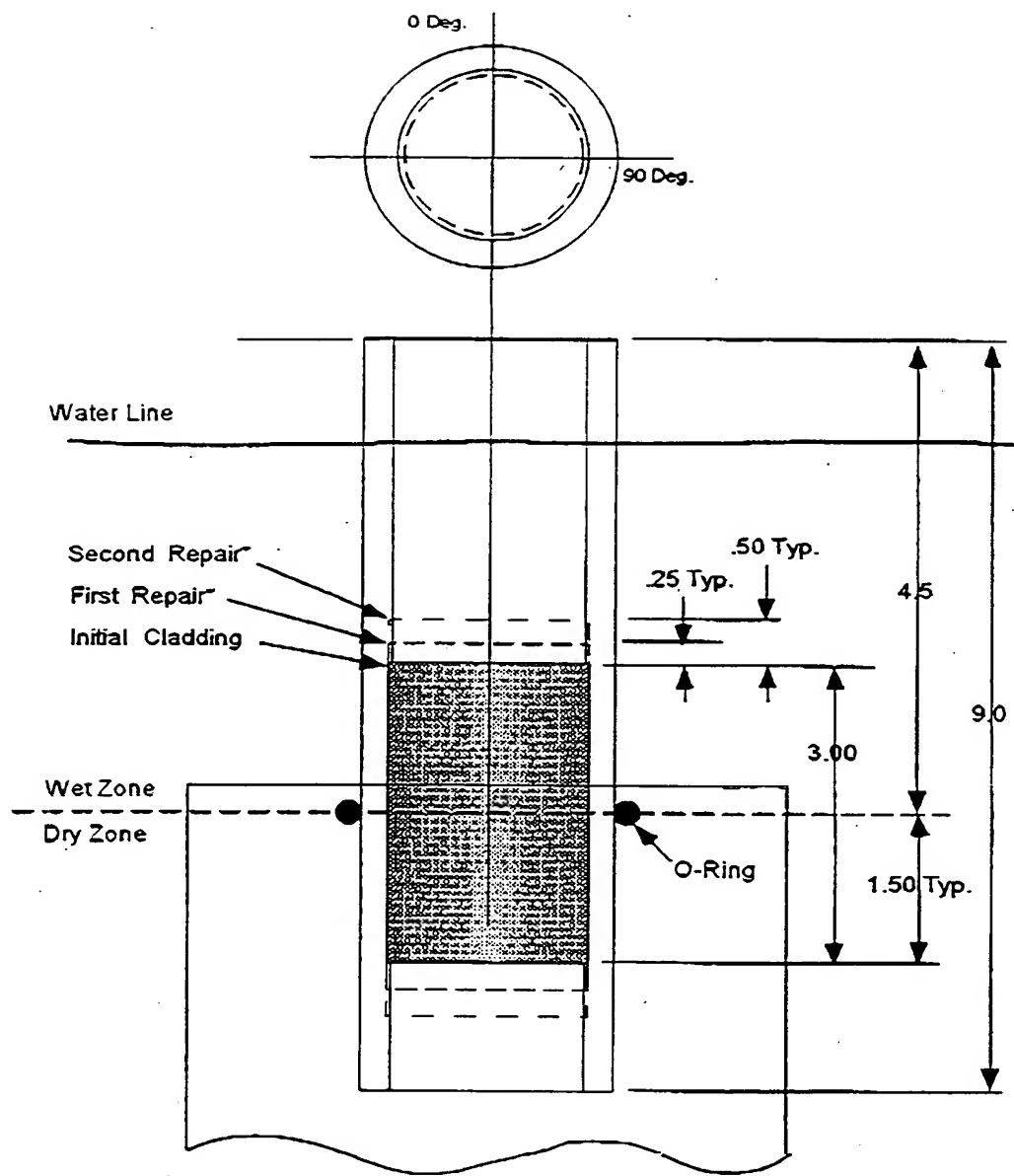
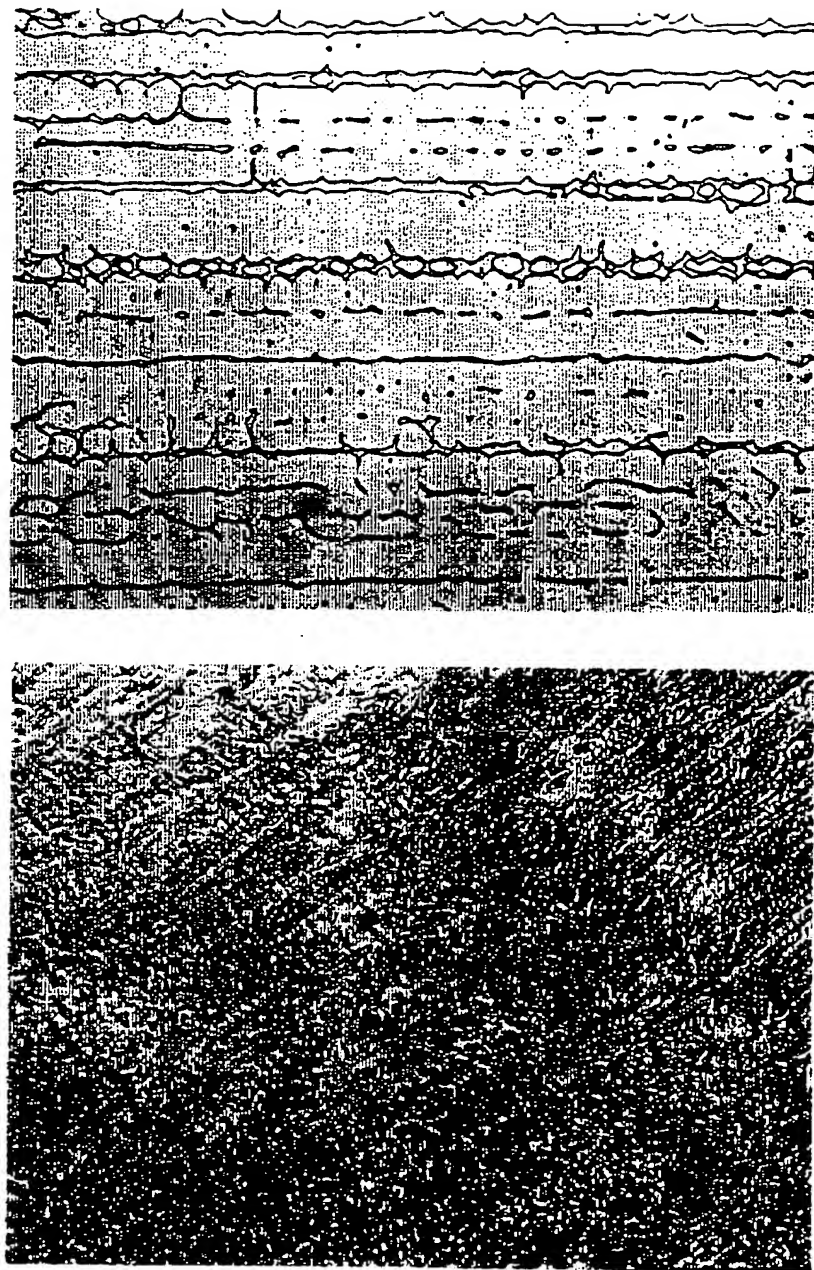


FIG. 7



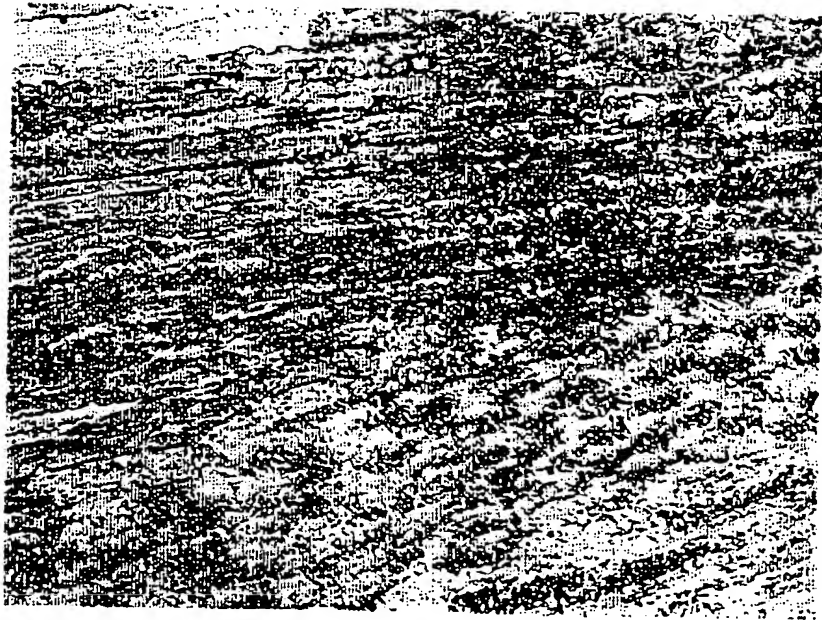
(A)

(B)

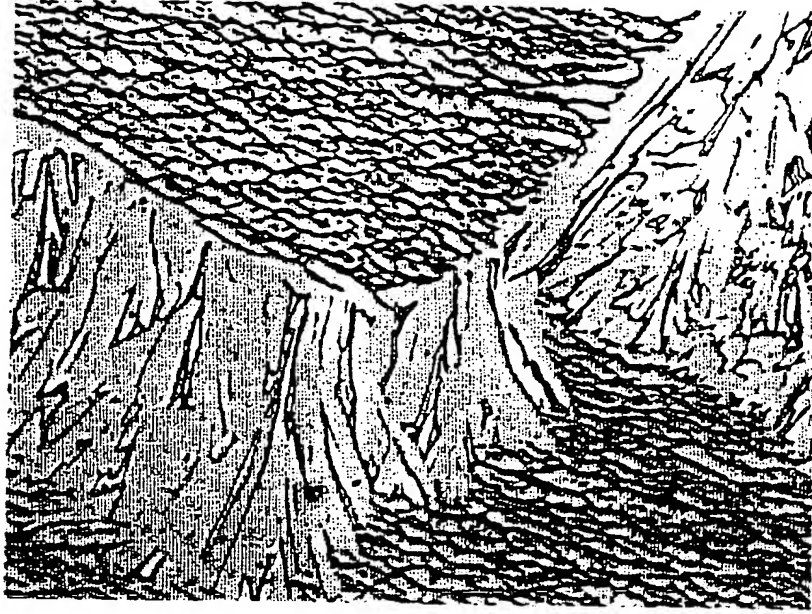
Micrographs Comparing Ferrite Size and Distribution for NM Cladding with Type 316L +1Pd Filler, 800 X Magnification. (A) Mechanized ICMH Cladding, (B) Manual Cladding

FIG. 8

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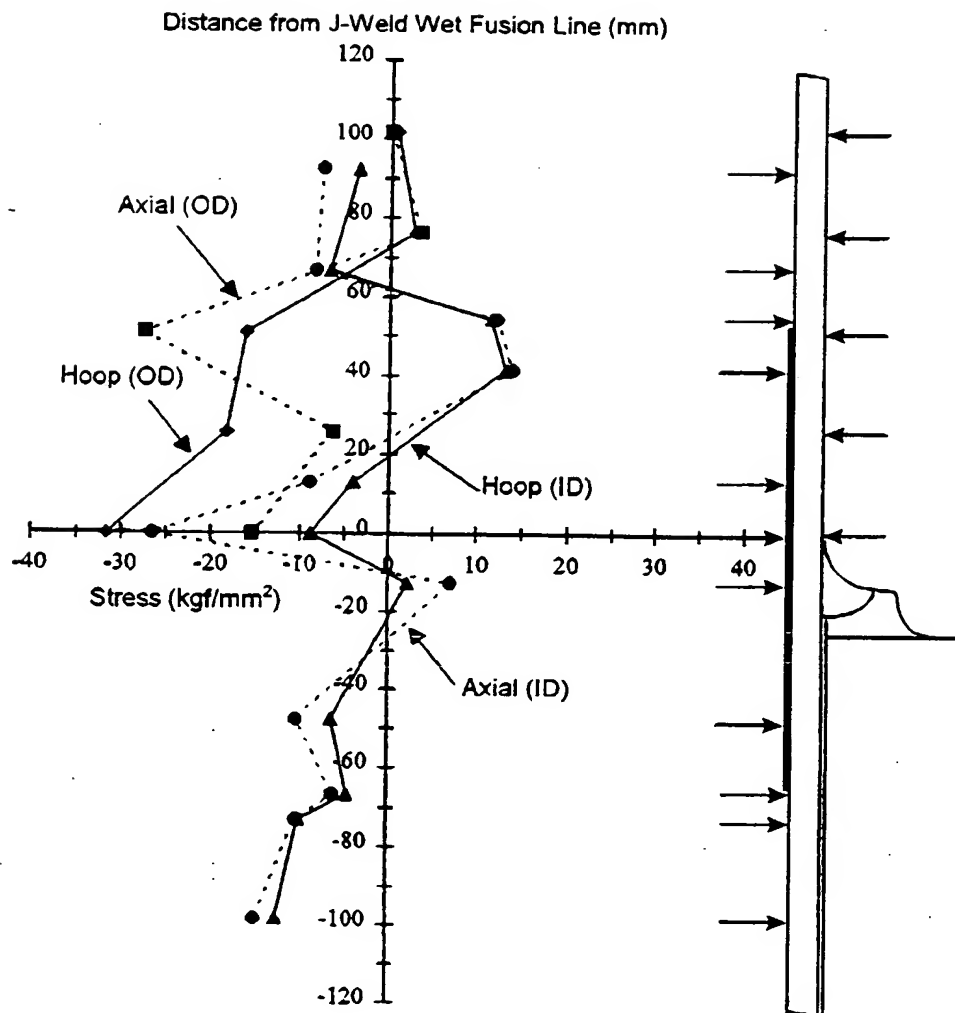
(A)



(B)

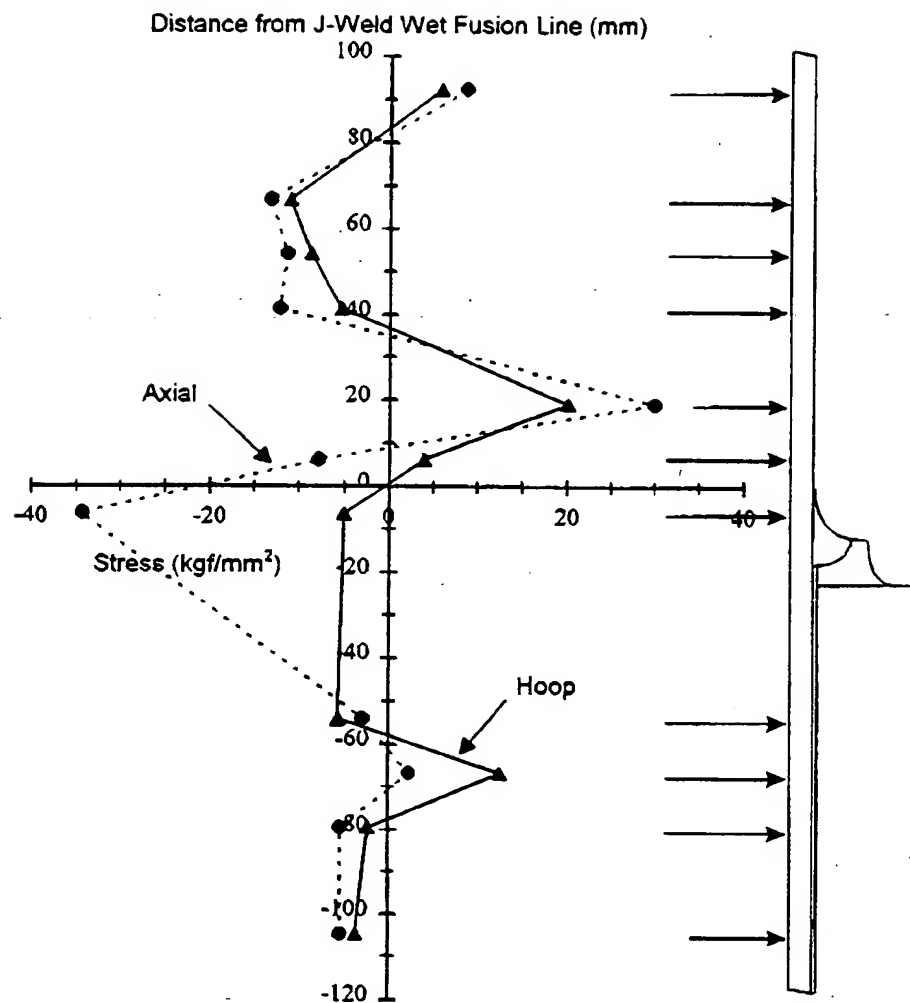
Micrographs Comparing Ferrite Size and Distribution for NM Cladding with Type 308L +1Pt Filler, 800 X Magnification. (A) Mechanized ICMH Cladding, (B) Manual Cladding

Fig. 9



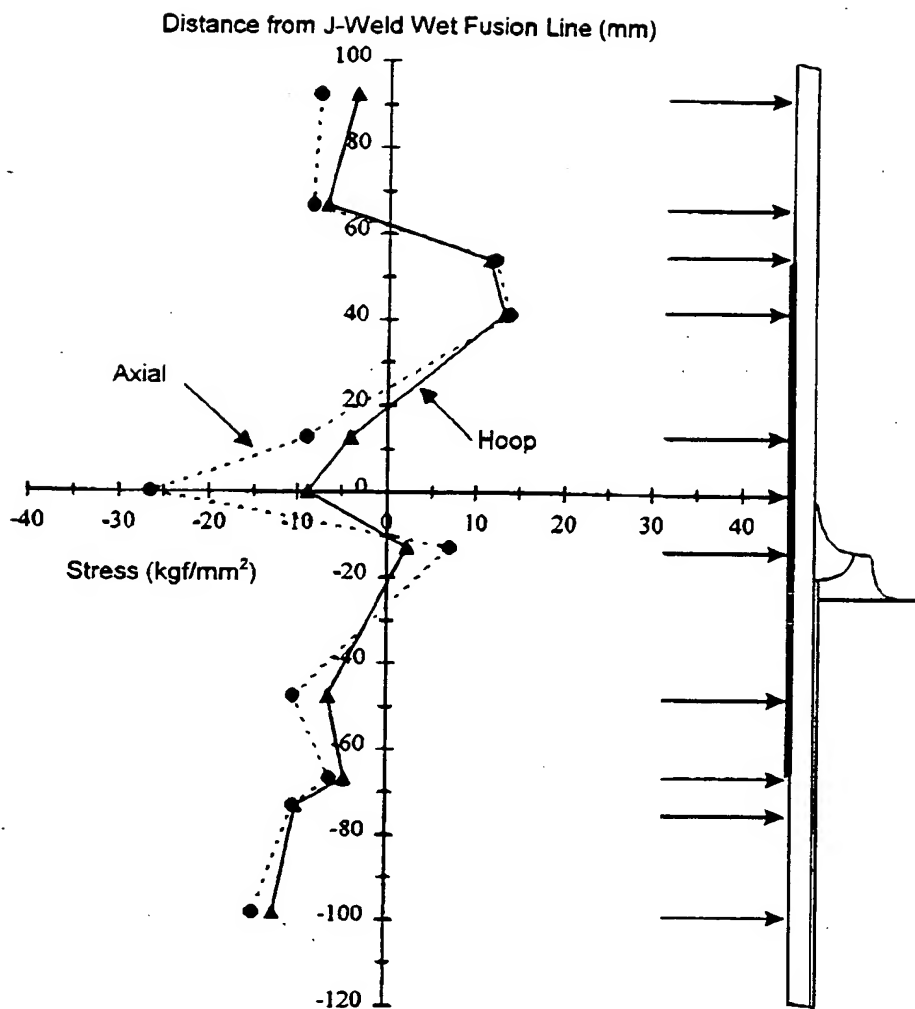
ID/OD Residual Stress (Clad)

FIG. 10A



ID Residual Stress (no clad)

FIG. 10 B



ID Residual Stress (clad)

FIG. 10C